

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010642**Date Inspected:** 05-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector observed 6CW crossbeam side - side panel was buckled at panel point 44. Dimensional check has been performed and the readings are as

From bottom panel 750mm – maximum deflection 22mm

From bottom panel 2700mm – maximum deflection 41mm

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (6BE-6CE)****SAW Process:**

Welding of weld joint –003 located on PCMK OBE6A, Deck panel. Welder is identified as 046830. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232(1) T-2.

**SAW Process:**

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Welding of weld joint –003 located on PCMK OBE6A, Deck panel. Welder is identified as 049804. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232(1) T-2.

FCAW Process:

Welding of weld joint –004 located on PCMK OBE6C, Bottom panel. Welder is identified as 053742. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

FCAW Process:

Welding of weld joint –003 located on PCMK OBE6C, Side panel. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

FCAW Process:

Welding of weld joint –003 located on PCMK OBE6C, Side panel. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG # TRIAL ASSEMBLY YARD (5CW-6AW)

FCAW Process:

Welding of weld joint –025 located on PCMK SP147-001, Side panel hold back area on T-Rib web. Welder is identified as 066746. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW Process:

Welding of weld joint –027 located on PCMK BP031-001, Side panel hold back area on T-Rib web. Welder is identified as 066674. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Manikandan,Murugan

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer